

Work Order ID 58936

May 26, 2010 10:20:06 AM



Page 1

Item ID: D205-596-107

Accept



Setup Start



Revision ID:

Stop



Item Name: Crosstube Aft Extended

Start Date: 5/20/10 Start Qty: 1.00



Cust Item ID:

Required Date: 6/07/10 Req'd Qty: 1.00

Customer:

Reference:

Run Start



Approvals: Process Plan: *W*

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D205-596

Rev B

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy D205-594 bluefile & type labels per PPP D205-596-107 CHG002

Handwritten: BG 10/06/04

Handwritten: S10/06/04

110

0.00



BENDING MACHINE - CROSSTUBES

CNC Bend 2

Memo

0.00

CNC Alpha 160 Bender

Bend as per Dwg D2890 using CNC bender program

Handwritten: (IX) MB 10-05-26

120

0.00



Crosstubes

Crosstubes

Memo

0.00

Crosstubes

Mark 20.36" for cutting from tangential line in the straight section from D2890 as per Dwg wall template.

Handwritten: N/A 10-05-26

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC15- Crosstube Dimensional Check

0.00



QC

Memo

0.00

Quality Control

140

Crosstubes

Mark cut line at 29.750"

0.00



Crosstubes

Memo

0.00

Crosstubes

1-Cut as per Dwg D205-596-107

2-Deburr & Inspect for surface damage. Polish cut surface. Scribe part # and batch # on one end of tube.

150

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Man S 10/05/27

XL

MB 10-05-27

2- 1- ALUM 10-3-27

S 10/05/31

XL

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Customer:

Reference:

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

Crosstubes Chemical Conversion
HandFinishing

0.00



HandFXtube

Memo

0.00

Hand Finishing Crosstubes

Touch up ends of the tube with Chemical Conversion Coat per QSI 005 4.1

1 - - - - - AW 10-5-08

170

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

8/10/05/31

66

180

SprayPaint

0.00



SprayPaint

Memo

0.00

Spray Painting

I-Prime inside and outside with Immron per QSI 005 4.2

m/l 10 06 01 01

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Cust Item ID:

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

190

QC14- Inspect Spray Paint

0.00



QC

Memo

0.00

Quality Control

10 06-02



200

Crosstubes

0.00



Crosstubes

Memo

0.00

Crosstubes

1- Lightly scuff the bonded area using a 320 grit sand paper and clean the area with 41058 wash 'n' wipe
2- Apply magnobond 6398 as per dwg D205-596-107 Magnobond 6398
Batch: 114021 EXP: 01/2011
3-Inst

Torque: M 10.06.03

10 06 02



210

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

5 10.06.03

10 06 03

| W/O: | | WORK ORDER CHANGES | | | | | |
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Page 5

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Item Name: Crosstube Aft Extended

Start Date: 5/20/10 Start Qty: 1.00



Cust Item ID:

Required Date: 6/07/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 220 | | 0.00 | | | | | | | |
| | Packaging | | | | | | | | |
| Packaging | Memo | 0.00 | | | | | | | |
| Packaging | Identify and pack for shipping as per PPP D205-596-107 | | | | | | | | |
| | Location: _____ | | | | | | | | |
| | PPP Rev: <u>RE</u> | | | | | | | | |
| 230 | | 0.00 | | | | | | | |
| | QC21- Final Inspection - Work Order Release | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

PC146/9 RE

10/06/07 MF
10-6-7.

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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NOTE: Date & initial all entries

Picklist Print

May 26, 2010 10:20:05 AM

Page 1

Work Order ID: 58936

Parent Item: D205-596-107

Parent Item Name: Crosstube Aft Extended

Start Date: 5/20/10

Required Date: 6/07/10

Comments: IPP Rev:D 05.03.21 Added bending procedure KJ/JLM
 IPP Rev:E 08-01-10 ECN 1075 DD
 IPP Rev F 08.04.28 Added bending & mat'l EC verified by: DD

Start Qty: 1.00

Required Qty: 1.00

| Component Item ID/ | Replacement | Mfg/ | Bin | Primary | Last | Route | Unit of | Qty on | Qty per Kit | Total | Qty | Date | Status |
|--------------------|-------------|--------------|-----|---------|------|-------|---------|---------|-------------|-------|-----|------|--------|
| D2940-1 | | Manufactured | No | | | 200 | Each | 45.0000 | 2 | 2 | | | |



Support

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| LG | 45 | |
| 45203 | 1 | |
| 47748 | 16 | |
| 52752 | 8 | |
| 57338 | 20 | |

W/ 10 06 02

D6008-180

Manufactured No

110 Each

11.0000

1

1



Crosstube Extrusion

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| LG | 11 | |
| 46779 | 11 | |

W/ 10-06-02

MS21920-28

Purchased No

200 Each

151.0000

4

4



Clamp(per MIL-DTL-8783C)

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| FG | 5 | |
| 105884 | 5 | |
| LG | 146 | |
| 112624 | 2 | |
| 112863 | 42 | |
| 113776 | 2 | |
| 114749 | 100 | |

W/ 10.06.02

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Page 2

May 26, 2010 10:20:05 AM

Work Order ID: 58936



Parent Item: D205-596-107



Parent Item Name: Crosstube Aft Extended

Start Date: 5/20/10

Required Date: 6/07/10

Comments: IPP Rev:D 05.03.21 Added bending procedure KJ/JLM
 IPP Rev:E 08-01-10 ECN 1075 DD
 IPP Rev F 08.04.28 Added bending & mat'l EC verified by: DD

Start Qty: 1.00

Required Qty: 1.00

| Component Item ID/ | Replacement | Mfg/ | Bin | Primary | Last | Route | Unit of | Qty on | Qty per Kit | Total | Qty | Date | Status |
|--------------------|-------------|--------------|-----|---------|------|-------|---------|---------|-------------|-------|-----|------|--------|
| D3595-063-530 | | Manufactured | No | | | 200 | Each | 96.0000 | 4 | 4 | | | |



RUBBER CUSHION

| Location | Loc Qty | Loc Code |
|--------------|---------|----------|
| FP | 96 | |
| 50030 | 20 | |
| <u>51776</u> | 76 | |

m 10.06.02

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

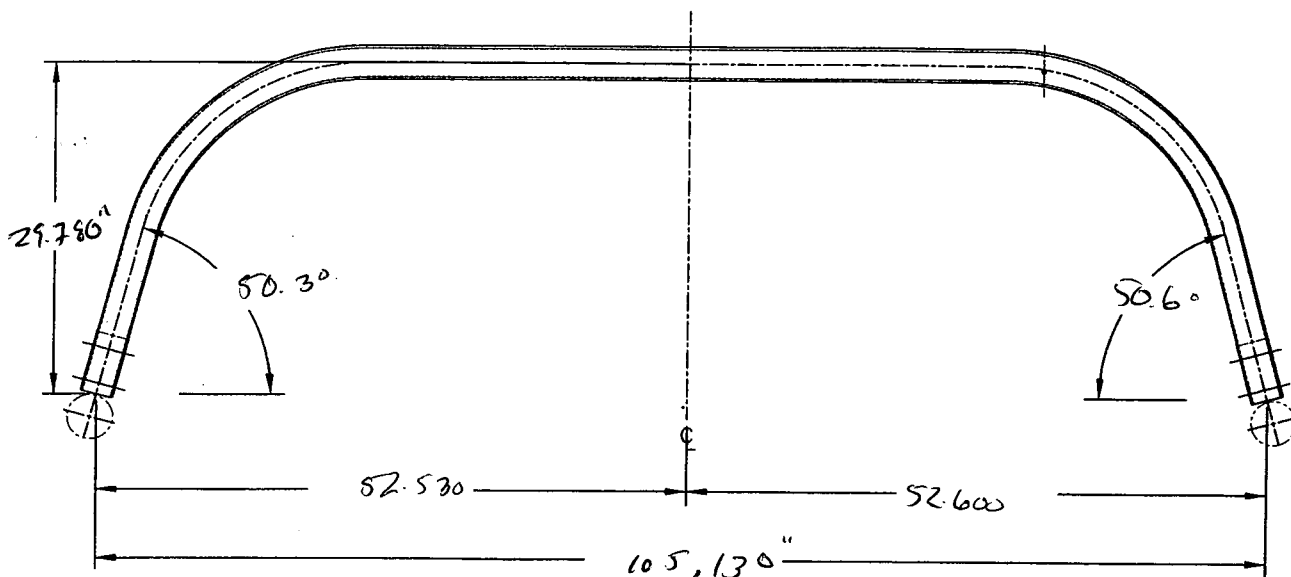
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

| | | | |
|--------------------------------------|--|--------------|--------------|
| DART AEROSPACE LTD | | Work Order: | 58936 |
| Description: Crosstube High-High Aft | | Part Number: | D205-596-107 |
| Inspection Dwg: D205-596-107 Rev: B | | Page 1 of 1 | |

| Required Dimension | Min | Max |
|--------------------|-------|-------|
| Height | 29.7 | 29.9 |
| 1/2 Span | 52.4 | 52.6 |
| Angle | 49 | 52 |
| Total Span | 104.8 | 105.2 |



| Comments |
|----------------------------|
| * Mark cut line at 29.780" |
| |
| |
| |

| | |
|-----------------|----------|
| QC15 Inspection | S |
| Date | 10/05/27 |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|-----------------|------------|----------|
| A | 07.02.06 | New Issue | KJ/JM | |
| B | 08.04.21 | Dwg Rev updated | KJ/JM | |

| W/O: | | WORK ORDER CHANGES | | | | | |
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NOTE: Date & initial all entries

PARTS LIST:

| Qty | Part Number | Description |
|-----|----------------|---|
| X | D205-596-107 | CROSSTUBE ASSEMBLY, HI-HI AFT |
| 1 | D6008-180 | CROSSTUBE |
| 2 | D2940-1 | SUPPORT |
| 4 | D3595-063-530 | RUBBER CUSHION |
| 4 | MS21920-28 | CLAMP |
| A/R | MAGNOBOND 6398 | ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE) |

GENERAL NOTES:

- 1) MATERIAL: MANUFACTURE FROM D6008-180
FINISHED LENGTH = 127.28 ± 0.02
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART 005 4.2
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH
VIBRATING STYLUS
- 7) WEIGHT: 50 lbs
- 8) PART IS SYMMETRIC ABOUT CENTERLINE
- 9) BEND PROGRESSIVELY WITH A MINIMUM OF 3 PASSES. MAXIMUM TUBE FLATTENING DUE TO
BENDING IS 6% BASED ON O.D.
- 10) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE
OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS
SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT
LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 11) APPLY A 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 TO THE SURFACE OF D2940-1 THAT
WILL BE IN CONTACT WITH THE CROSSTUBE. LET CURE FOR 12 HOURS AFTER INSTALLATION
AND PRIOR TO PACKAGING.
- 12) INSTALL MS21920-28 CLAMPS WITH D3595-063-530 RUBBER CUSHIONS TO SECURE D2940-1
SUPPORT ON THE TOP SIDE OF THE CROSSTUBE. ENSURE CLAMPS ARE OPPOSITE
CROSSTUBE SUPPORT.
**NOTE: IT IS ACCEPTABLE TO SUBSTITUTE MS21920-28 CLAMPS WITH LONGER OR SHORTER
MS21920-XX CLAMPS TO ACCOMMODATE VARYING DIAMETERS. ENSURE THERE IS A MINIMUM OF
1.5 THREADS IN SAFETY ON THE NUTS.**
- 13) TORQUE CLAMPS 80 TO 100 IN-LB

DEO ATTACHED

WLO 58436

RECEIVED
07-12-03

| | | | |
|------------|---|--|--------------|
| B | SUPPORT NOW MAGNOBONDED; REMOVE D2856-600-1009 ABRASION STRIP; UPDATED NOTES; ADDED D3595-063-530 CUSHION | MB | 07.12.03 |
| A | NEW ISSUE | DS | 02.11.20 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | <i>[Signature]</i> | DART AEROSPACE LTD | |
| DRAWN | <i>[Signature]</i> | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | <i>[Signature]</i> | DRAWING NO. | REV. B |
| MFG. APPR. | <i>[Signature]</i> | D205-596-107 | SHEET 1 OF 2 |
| APPROVED | <i>[Signature]</i> | TITLE | SCALE |
| DE APPR. | <i>[Signature]</i> | CROSSTUBE ASSEMBLY, HI-HI AFT | NTS |
| DATE | 07.12.03 | <small>COPYRIGHT © 2002 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small> | |

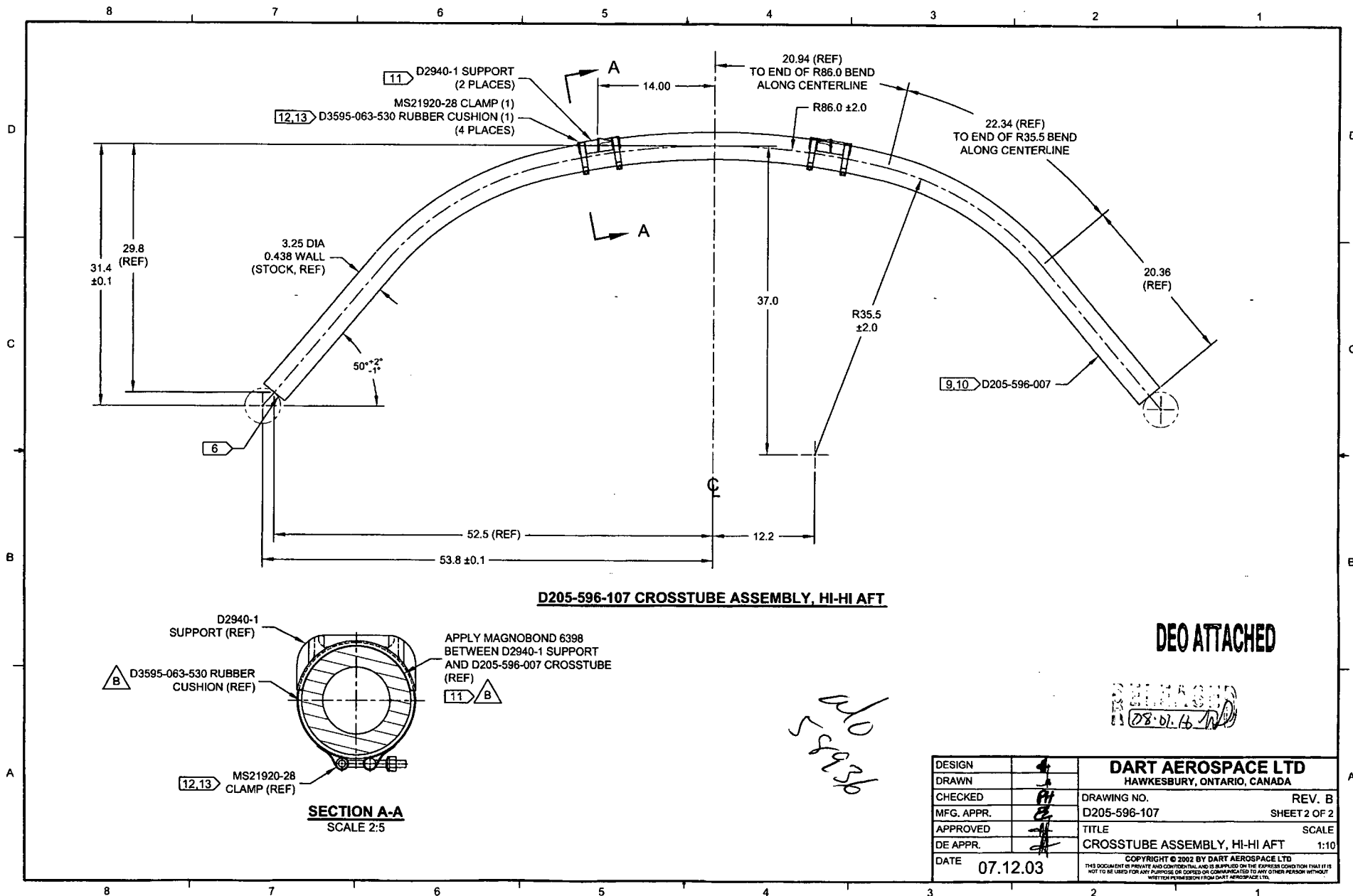
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NOTE: Date & initial all entries



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|-----------------------------|----------------------|-------------------------|---|--|--------------------------------|---------------------------|--------------|
| DRAWING NO. D205-596-107 | TITLE CROSSTUBE | REV. B | DART AEROSPACE LTD ENGINEERING ORDER | | D.E.O. NO. D205-596-107-B-1 | SHEET NO. SHEET 1 OF 1 | SCALE NTS |
| DRAWN <i>AD</i> | CHECKED <i>PH</i> | MFG. APPR. <i>CE</i> | APPROVED <i>MD</i> | | DE APPR. <i>H</i> | | |
| DATE 09.05.01 | DATE 09.06.15 | DATE 09.06.15 | DATE 09/06/16 | | DATE 09/06/16 | | |

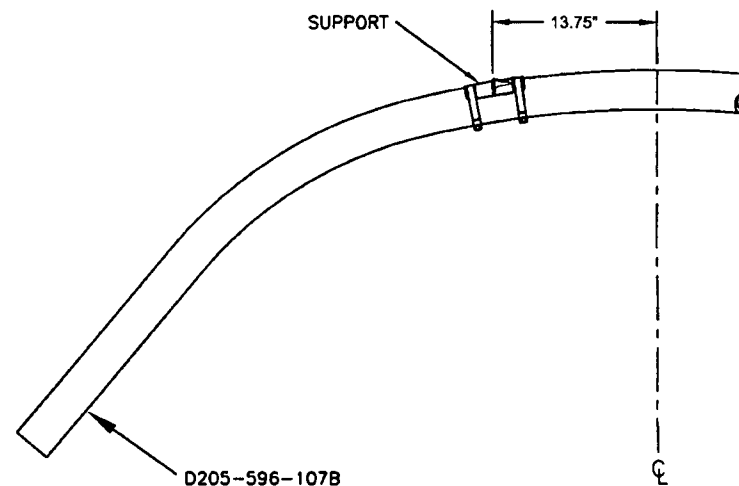
CHANGE:

ADD THE FOLLOWING CROSSTUBE ASSEMBLY:

| Part Number | Description |
|---------------|------------------------------------|
| D205-596-107B | CROSSTUBE ASSEMBLY (214 HI-HI AFT) |

THE D205-596-107B CROSSTUBE HAS THE SAME PARTS LIST AS THE D205-596-107 CROSSTUBE. HOWEVER, INSTALL THE SUPPORTS AS SHOWN IN FIGURE 1 OF THIS ENGINEERING ORDER. THE NEW KIT IS OTHERWISE ASSEMBLED PER THE D205-596-107 CROSSTUBE.

RELEASED
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FIGURE 1 - SUPPORT INSTALLATION